

SPLIT

Work Order ID 149207 - ~~2/3/14~~  
July 21, 2016 3:21:59 PM

\*149207\*

~~DRAB GREEN~~ Page 1

Item ID: D3405-043

Revision ID:

Item Name: Ground Handling Lug

Start Date: 9/20/2016 Start Qty: 10.00

Required Date: 9/30/2016 Req'd Qty: 10.00

Reference:

Accept

\*N900040100\*

Setup Start

\*NS1\*

Stop

\*NS2\*

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr                       | Revision Nbr             |                      |         |        |              |               |               |                  |                |
| D3405                          | Rev B                    |                      |         |        |              |               |               |                  |                |

100

\*100\*

Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

1-Cut as per Dwg D3405

Dwg Rev: BProg Rev: B

2-Deburr if necessary

0.00

0.17

152065

22

DAS  
2016/6/29 50  
9-89

110

\*110\*

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.03

22

DAS  
2016/6/29 50  
9-89

120

\*120\*

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.03

(22)

JUL 29 2016

# Work Order ID 149207

July 21, 2016 3:21:59 PM

**\*149207\***

Page 2

Item ID: D3405-043 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Ground Handling Lug  
 Start Date: 9/20/2016 Start Qty: 10.00 **\*10\*** Cust Item ID:  
 Required Date: 9/30/2016 Req'd Qty: 10.00 **\*10\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID                | Operation<br>Description                                                                                                             | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code      | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|-----------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------|----------------------|---------|--------|-------------------|---------------|---------------|------------------|----------------|
| 130<br><b>*130*</b><br>Brake NC<br>Brake NC   | NC BRAKE<br><br>Memo<br>1-Debur<br>2-Form using DT8204 as per Dwg D3405<br>3- use DT9681 to check if correct forming                 | 0.02<br><br>0.07     |         |        | DAS<br>30<br>0.02 | 22            |               |                  | AUG 17 2016    |
| 140<br><b>*140*</b><br>QC<br>Quality Control  | QC5- Inspect part completeness to step on W/O<br><br>Memo                                                                            | 0.00<br><br>0.03     |         |        |                   | (22)          |               |                  | AUG 18 2016    |
| 150<br><b>*150*</b><br>Large Fab<br>Large Fab | Weld per dwg A/R S.S. rod Batch: <u>116577</u><br>Large Fab<br><br>Memo<br>Weld as per Dwg D3405 use DT8484<br>Identify as D3405-043 | 0.00<br><br>0.23     |         |        |                   | 22            |               | 16-09-01<br>JML  |                |

# Work Order ID 149207

Monday, July 25, 2016 9:00:59 AM

**\*149207\***

Page 3

Item ID: D3405-043 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Ground Handling Lug  
 Start Date: 9/20/2016 Start Qty: 10.00 **\*10\*** Cust Item ID:  
 Required Date: 9/30/2016 Req'd Qty: 10.00 **\*10\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description                     | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp   |
|--------------------------------|----------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|------------------|
| 160                            | QC9- Inspect visual per QSI004- Fusion Welds | 0.00                 |         |        |              |               |               |                  |                  |
| <b>*160*</b>                   |                                              |                      |         |        |              |               |               |                  |                  |
| QC                             | Memo                                         | 0.03                 |         |        |              | (27)          | 160902        |                  | DAS<br>9<br>9-89 |
| Quality Control                |                                              |                      |         |        |              |               |               |                  |                  |

|                 |                                               |      |  |  |  |      |        |  |                  |
|-----------------|-----------------------------------------------|------|--|--|--|------|--------|--|------------------|
| 170             | QC5- Inspect part completeness to step on W/O | 0.00 |  |  |  |      |        |  |                  |
| <b>*170*</b>    |                                               |      |  |  |  |      |        |  |                  |
| QC              | Memo                                          | 0.03 |  |  |  | (22) | 160902 |  | DAS<br>9<br>9-89 |
| Quality Control |                                               |      |  |  |  |      |        |  |                  |

|                |                                        |      |  |  |  |  |  |  |  |
|----------------|----------------------------------------|------|--|--|--|--|--|--|--|
| 185            |                                        | 0.00 |  |  |  |  |  |  |  |
| <b>*185*</b>   |                                        |      |  |  |  |  |  |  |  |
| SprayPaint     | Memo                                   | 0.00 |  |  |  |  |  |  |  |
| Spray Painting | PRIME B<br>SPRAY PAINT DRAB GREEN<br>B |      |  |  |  |  |  |  |  |

*Handwritten notes:*  
 N/A  
 close w/o > pull to new w/o  
 for 12  
 to powdercoat white  
 w/ 16-10-19  
 (Too many made for Drab Green on this w/o)  
 152065

**Work Order ID 149207**

Monday, July 25, 2016 9:01:12 AM

**\*149207\***

Page 4

Item ID: D3405-043

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Ground Handling Lug

Stop **\*NS2\***

Start Date: 9/20/2016 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 9/30/2016 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***Stop **\*NR2\***

| Sequence ID/<br>Work Center ID                | Operation<br>Description                                | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|-----------------------------------------------|---------------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 195<br><b>*195*</b><br>QC<br>Quality Control  | QC14- Inspect Spray Paint<br><br>Memo                   | 0.00<br>0.00         |         |        |              |               |               |                  |                |
| 200<br><b>*200*</b><br>Packaging<br>Packaging | Identify as per dwg & Stock Location: _____<br><br>Memo | 0.00<br>0.17         |         |        |              |               |               |                  |                |
| 210<br><b>*210*</b><br>QC<br>Quality Control  | QC21- Final Inspection - Work Order Release<br><br>Memo | 0.00<br>0.02         |         |        |              |               |               |                  |                |

W 16-019  
12



# Picklist Print

July 21, 2016 3:21:59 PM

Page 1

Work Order ID: 149207

Parent Item: D3405-043

Parent Item Name: Ground Handling Lug

**\*149207\***  
**\*D3405-043\***

Start Date: 9/20/2016

Required Date: 9/30/2016

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP A05.09.01 New issue KJ/JLM  
IPP B 09.01.28 Rev b dwg EC verified by: DD

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D3404-1                         |                        | Manufactured  | No          |                     |                  | 100             | Each               | 38.0000        | 1           | 10           |               |                |        |

**\*D3404-1\***

GHW/ Lug

Location

WA001

Loc Qty

38

Loc Code

145962

38

Purchased

No

150

sf

47.8369

0.154

1.621053

M304S11GA

**\*M304S11GA\***

304/316 0.125 Sheet

Location

MAT020

Loc Qty

37.52998

Loc Code

M129545

27.33998

M129972

7.4

M134284

2.79

TPI

10.3069336

M134604

10.3069336

16-08-01  
JBC

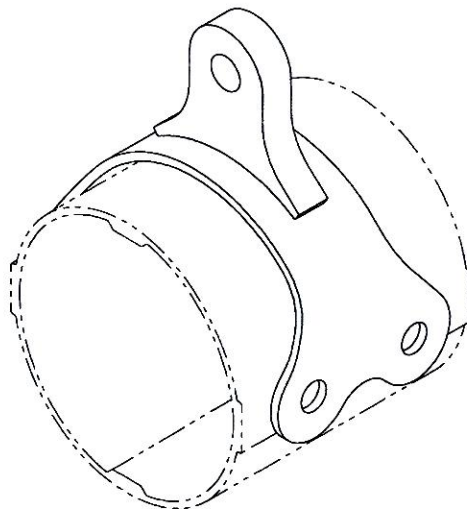
PR 2016/07/29

3

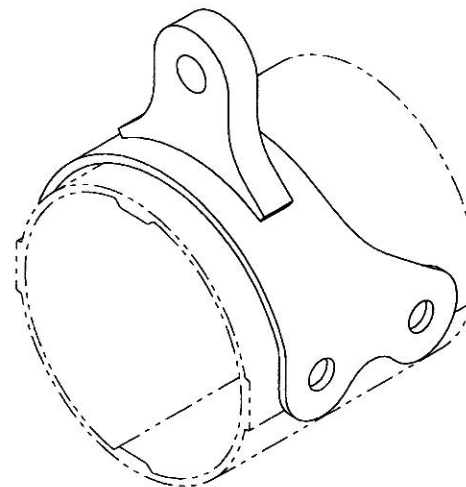


| ITEM No. | QTY. -041 | QTY. -043 | PART NUMBER | DESCRIPTION  |
|----------|-----------|-----------|-------------|--------------|
| 1        | X         |           | D3405-041   | LUG ASSEMBLY |
| 2        |           | X         | D3405-043   | LUG ASSEMBLY |
| 11       | 1         | 1         | D3404-1     | GHW LUG      |
| 12       | 1         |           | D3405-1     | GHW BRACKET  |
| 13       |           | 1         | D3405-3     | GHW BRACKET  |

△B



**D3405-041 LUG ASSEMBLY**  
(SKID TUBE SECTION SHOWN  
FOR REF ONLY)



**D3405-043 LUG ASSEMBLY**  
(SKID TUBE SECTION SHOWN  
FOR REF ONLY)

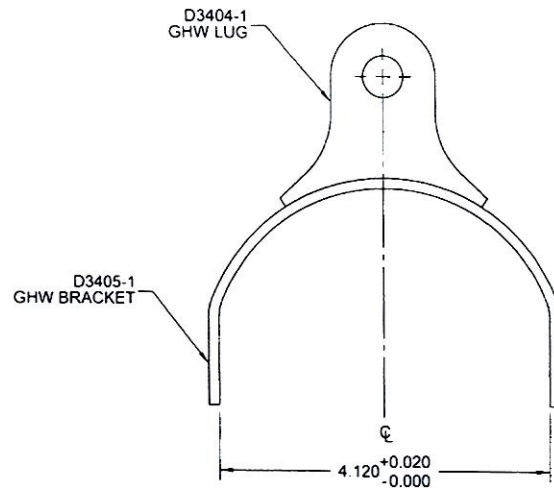
NOT TO SCALE  
UNCONTROLLED COPY  
NOT TO BE USED FOR FABRICATION  
DATE 149207 MKS  
1607-25

**RELEASED**  
08/12/18 MKS

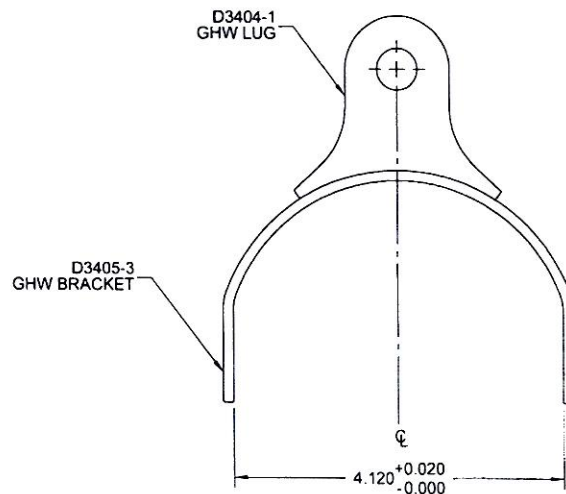
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER  
IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: -041, 0.85 lbs  
-043, 0.87 lbs

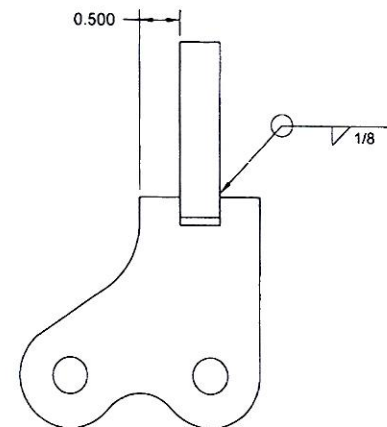
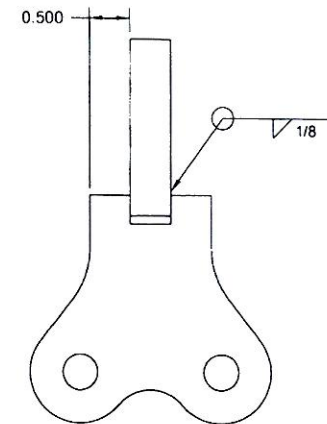
|            |                                                                                                                                                                                                                                 |                                                          |                                                                                                                                                                                                                                                                         |          |
|------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------|
| B          | DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER<br>FLAT PATTERNS FOR .1 & .3 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR 198). SHEETS 3 & 4<br>ZONE A5 4 120 DIM WAS 4 100 |                                                          | AJS                                                                                                                                                                                                                                                                     | 08.09.19 |
| A          | NEW ISSUE                                                                                                                                                                                                                       |                                                          | PH                                                                                                                                                                                                                                                                      | 05.03.08 |
| REV.       | DESCRIPTION                                                                                                                                                                                                                     |                                                          | BY                                                                                                                                                                                                                                                                      | DATE     |
| DESIGN     | PH                                                                                                                                                                                                                              | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                                                                                                                                                                                                                                                                         |          |
| DRAWN      | AJS                                                                                                                                                                                                                             |                                                          |                                                                                                                                                                                                                                                                         |          |
| CHECKED    |                                                                                                                                                                                                                                 | DRAWING NO.                                              | REV. B                                                                                                                                                                                                                                                                  |          |
| MFG. APPR. |                                                                                                                                                                                                                                 | D3405                                                    | SHEET 1 OF 4                                                                                                                                                                                                                                                            |          |
| APPROVED   |                                                                                                                                                                                                                                 | TITLE                                                    | SCALE                                                                                                                                                                                                                                                                   |          |
| DE APPR.   |                                                                                                                                                                                                                                 | GHW LUG ASSEMBLY                                         | NTS                                                                                                                                                                                                                                                                     |          |
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**D3405-041 LUG ASSEMBLY**



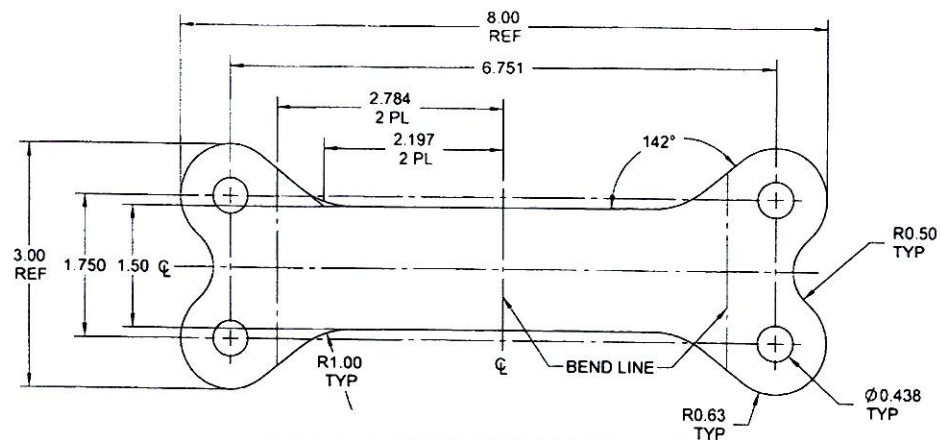
**D3405-043 LUG ASSEMBLY**



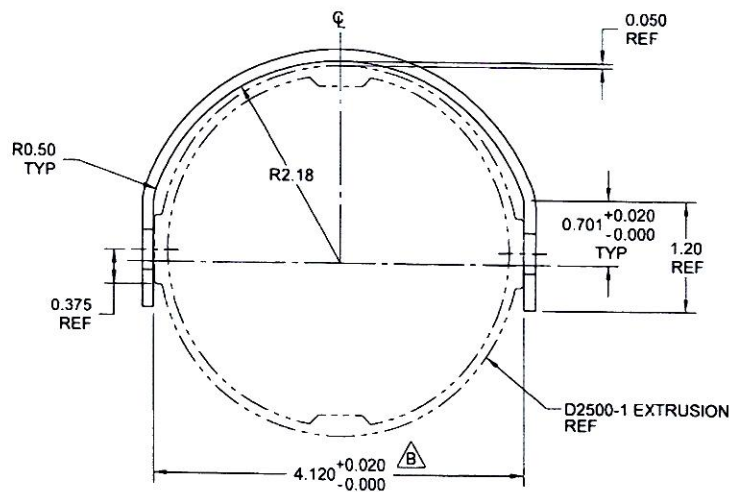
**RELEASED**  
06/12/18 MP

|            |          |                                                                                                                                                                                                                                                                                         |              |
|------------|----------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN     | PH       | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                                |              |
| DRAWN      | AJS      |                                                                                                                                                                                                                                                                                         |              |
| CHECKED    |          | DRAWING NO                                                                                                                                                                                                                                                                              | REV. B       |
| MFG. APPR. |          | D3405                                                                                                                                                                                                                                                                                   | SHEET 2 OF 4 |
| APPROVED   |          | TITLE                                                                                                                                                                                                                                                                                   | SCALE        |
| DE APPR.   |          | GHW LUG ASSEMBLY                                                                                                                                                                                                                                                                        | NTS          |
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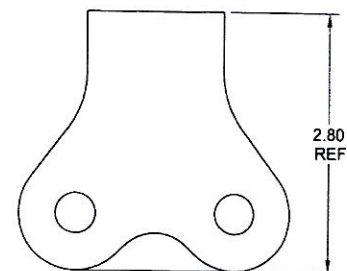




**D3405-1F GHW BRACKET FLAT PATTERN**



**D3405-1 GHW BRACKET**  
(MAKE FROM D3405-1F)



SIDE VIEW FOR REF ONLY

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)  
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524  
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

**RELEASED**  
07/08/14

|            |          |                                                                                                                                                                                                                                                              |              |
|------------|----------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN     | PH       | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                     |              |
| DRAWN      | AJS      |                                                                                                                                                                                                                                                              |              |
| CHECKED    |          | DRAWING NO.                                                                                                                                                                                                                                                  | REV. B       |
| MFG. APPR. |          | D3405                                                                                                                                                                                                                                                        | SHEET 3 OF 4 |
| APPROVED   |          | TITLE                                                                                                                                                                                                                                                        | SCALE        |
| DE APPR.   |          | GHW LUG ASSEMBLY                                                                                                                                                                                                                                             | NTS          |
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